

Mon/Tues

Date: Thursday, 7/19/2007 2:20:20 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PIN	
Job Number	: 33628				
Estimate Number	: 12672				
P.O. Number	: N/A		Part Number	: D31471	
This Issue	: 7/19/2007 S.O. No. : N/A		Drawing Number	: D3147 REV C	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: C	
Previous Run	: 31578		Material	: N/A	
Written By			Due Date	: 7/20/2007	
Checked & Approved By			Qty:	2	
Comment			Um:	Each	
<p><i>7/19/07, 07, 19</i></p> <p>Est Rev A New Issue 07-01-26 JLM Est Rev B Now on Cnc 07-05-02 JLM</p>					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M303R0187	303 Round Bar 0.187"	
		Comment: Qty.: 0.2363 f(s)/Unit Total : 0.4725 f(s) 303 Round Bar 0.187" Batch: <i>M103435</i>	<i>DTP 07/07/21 (2)</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: 1-TURN AS PER FOLIO FA691 & DWG D3147 , FOLIO REV: <i>AA</i> DWG REV: <i>C</i>	<i>DTP 07/07/21 (2)</i>
		2-DEBURR AS REQUIRED	<i>DTP 07/07/21 (2)</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>DTP 07/07/21 (2)</i>
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1	
		1- Mill as per Folio FA691 Rev: <i>C</i> & Dwg D3147 Rev: <i>C</i>	
		2-Deburr per dwg D3443	<i>Jeff 07/07/23 (2)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/07/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PIN

Job Number: 33628

Part Number: D31471

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



7/19/07-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0 QC8

SECOND CHECK



7/19/07-23

Comment: SECOND CHECK

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/19/23

2x50

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

7/19/07-23

Job Completion



7/19/07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

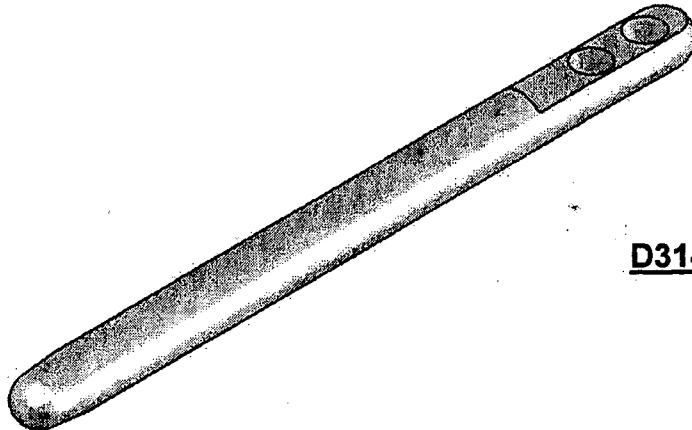
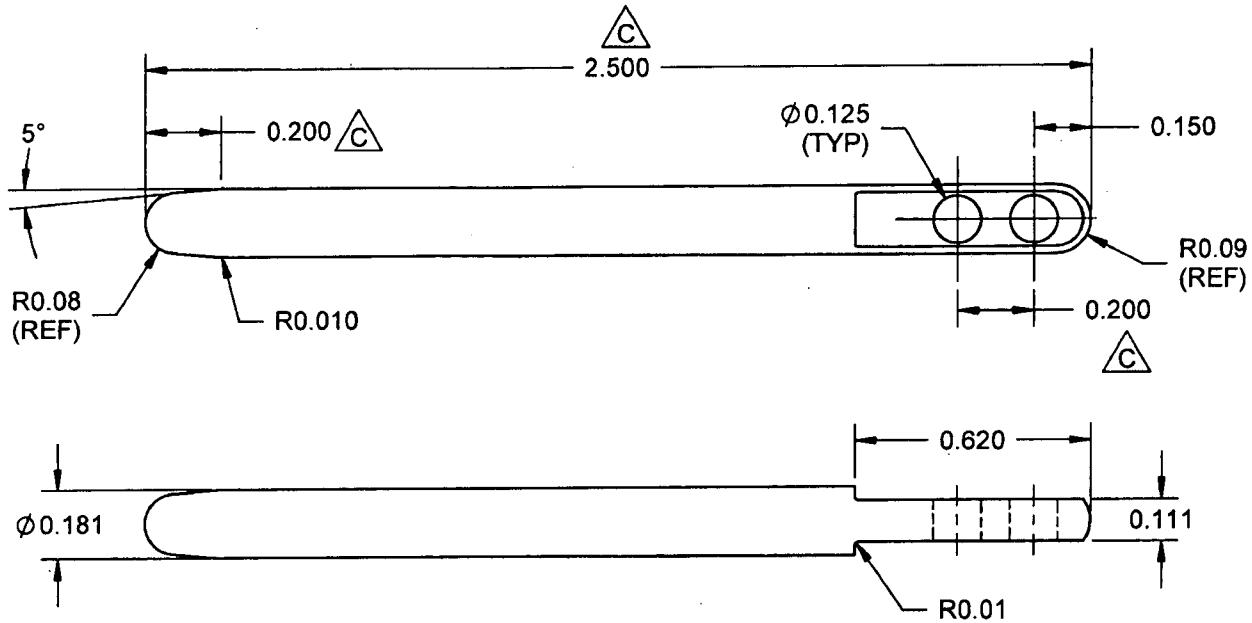
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>CE</i>	<i>TH</i>	D3147	SHEET 1 OF 1
DATE	06.12.04	TITLE	SCALE
		PIN	2:1
REV	DATE	DESCRIPTION	
A	02.04.23	NEW ISSUE	
B	04.10.18	ADD PART MARKING AND NORMALIZED	
C	06.12.04	ADD SECOND ϕ 0.125 HOLE; CHANGE MATERIAL; 0.200 TAPER WAS 0.400; REMOVE SUPPLIER AND FINISHING	

**D3147-1 PIN****RELEASED**

07-01-22

NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF DART SPEC M303R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3147-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015 MAX
- 7) REPLACES PREMIER P/N B30-23000-119

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
NOT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33628

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DART AEROSPACE LTD	Work Order:	33628
Description: Pin	Part Number:	103147
Inspection Dwg: C	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>DSP/CH</u>	Audited by: <u>EC</u>	Prototype Approval:
Date: <u>07/07/21</u>	Date: <u>07/07/21</u>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	